












Date: Thursday, 18/09/2008 11:12:31 AM
 User: Julie Lecocq



Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WELDMENT TOP PANEL
Job Number	: 42094		
Estimate Number	: 13028		
P.O. Number	:	Part Number	: D36501
This Issue	: 18/09/2008 S.O. No. :	Drawing Number	: D3650 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 39932	Material	:
Written By	:	Due Date	: 25/09/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JUD 08.9.18</u>		
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S26GA	304/316 0.018 SHEET	
			
Comment: Qty.: 1.6622 sf(s)/Unit Total : 8.3108 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>109398</u> <u>B8-9-26</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3650 <u>B8-9-26</u> Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B8-9-26</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>S 08/09/29</u> <u>(46)</u>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form as per Dwg D3650 <u>SB 08/09/30</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 08/10/03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42094</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
02/09/29	20	Part found with Scrap 0.005" scratched in it. P.C. was on mat.		After Build Part is too thin after trying to repair Scrap and destroy no replace extra was cut on water Jet.	JB 08/09/30	S 08/09/30		S 08/09/29
				(Part is too thin after trying to remove scratch.) Scratch still shows.				

NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:12:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 42094

Part Number: D36501

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/30 (5)

7.0

MS20427M33

Rivet



Comment: Qty.: 18.0000 Each(s)/Unit Total: 90.0000 Each(s)

Rivet

batch: 1109371

FF 08/10/01 (5)

8.0

MS210603K

Nut Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Nut Plate

batch: 1109371

FF 08/10/01 (5)

9.0

MS210623K

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut Plate

batch: 1108669

FF 08/10/01 (5)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3650

FF 08/10/01 (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/02 (5)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: SA

08/10/02 (5)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42094
Description: Aft Panel		Part Number: D3650-1
Inspection Dwg: D3650	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

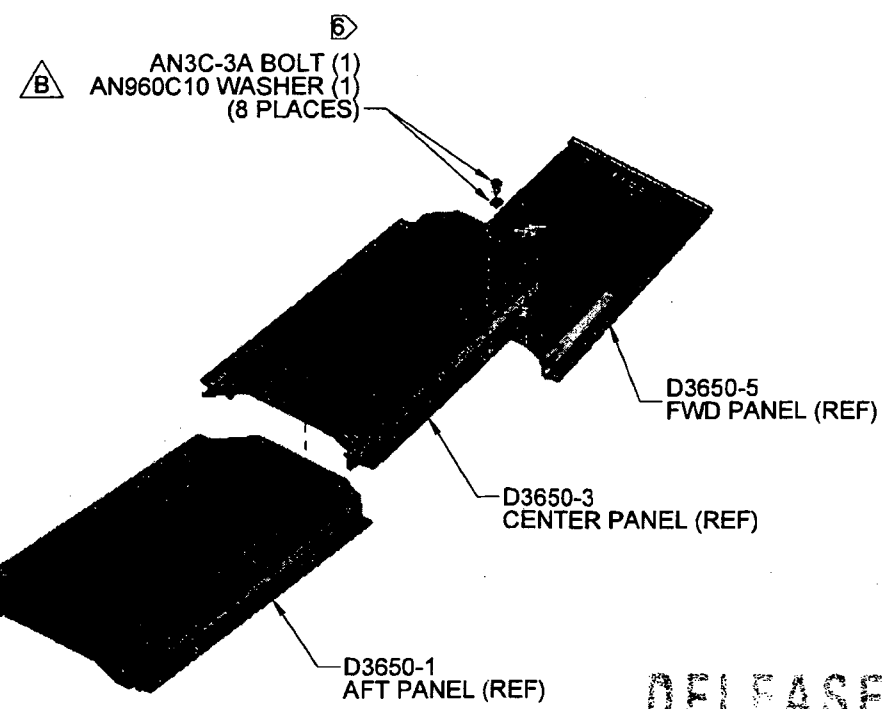
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.161	X			
Ø0.213	+0.005/-0.001	.216	X			
Ø0.250	+0.005/-0.001	.254	X			
0.35	+/-0.030	.353	X			
0.344	+/-0.010	.345	X			
0.312	+/-0.010	.316	X			
12.02	+/-0.030	12.02	X			
12.25	+/-0.030	12.20	X			
16.65	+/-0.030	16.28	X			
17.58	+/-0.030	17.58	X			
16.61	+/-0.030	16.61	X			
15.80	+/-0.030	15.80	X			
3.950	+/-0.010	3.950	X			
2.26	+/-0.030	2.259	X			
7.18	+/-0.030	7.185	X			
9.55	+/-0.030	9.55	X			
10.66	+/-0.030	10.66	X			
0.40	+/-0.030	.401	X			
2.02	+/-0.030	2.025	X			
4.03	+/-0.030	4.027	X			
6.13	+/-0.030	6.134	X			
8.23	+/-0.030	8.233	X			
10.31	+/-0.030	10.31	X			

Measured by: HB	Audited by: S	Prototype Approval:	N/A
Date: 8-9-26	Date: 08/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	

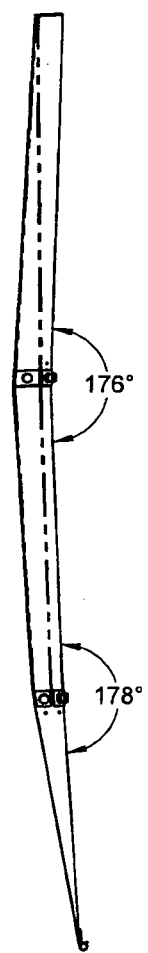
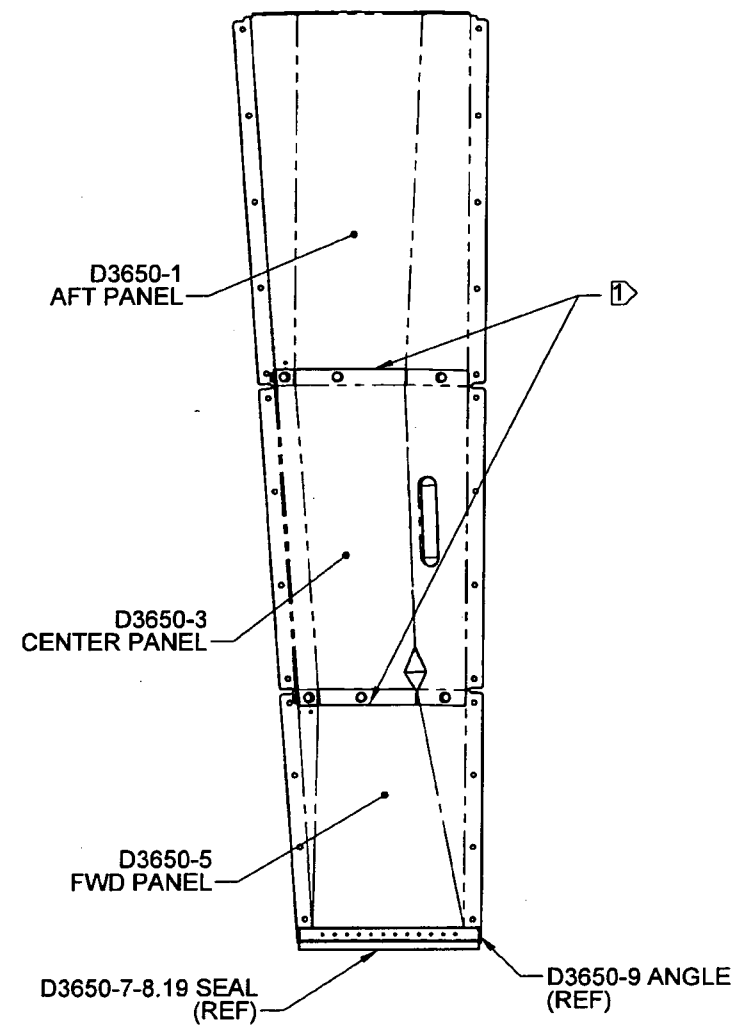
8 7 6 5 4 3 2 1



RELEASED
08-23-27/11/07

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



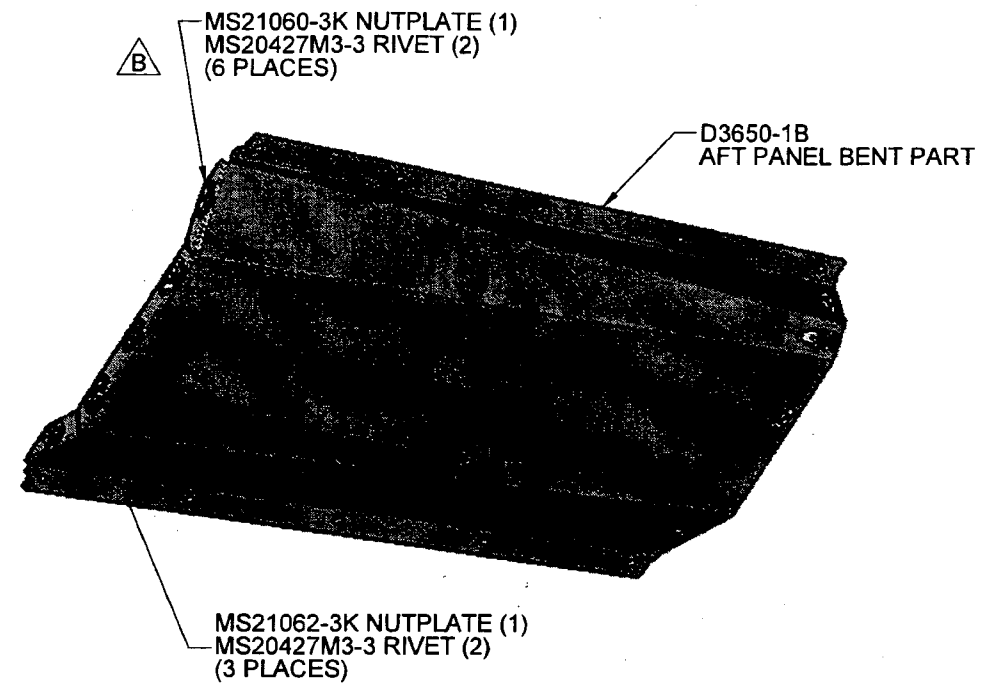
D3650-041 TUNNEL TOP PANEL ASSEMBLY

- NOTES:
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) TORQUE FASTENERS 15 TO 25 in-lb
 - 7) WEIGHT: 3.3 lbs

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 1 OF 1
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	18
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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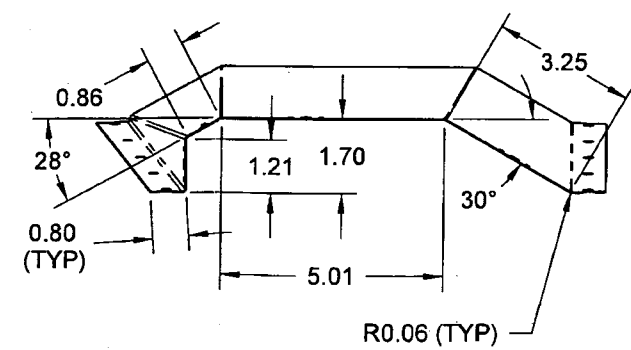
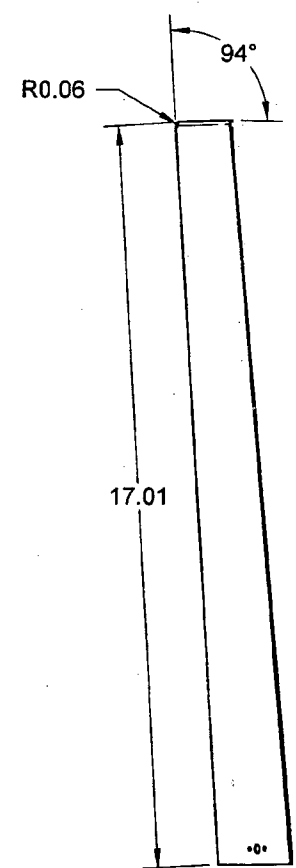
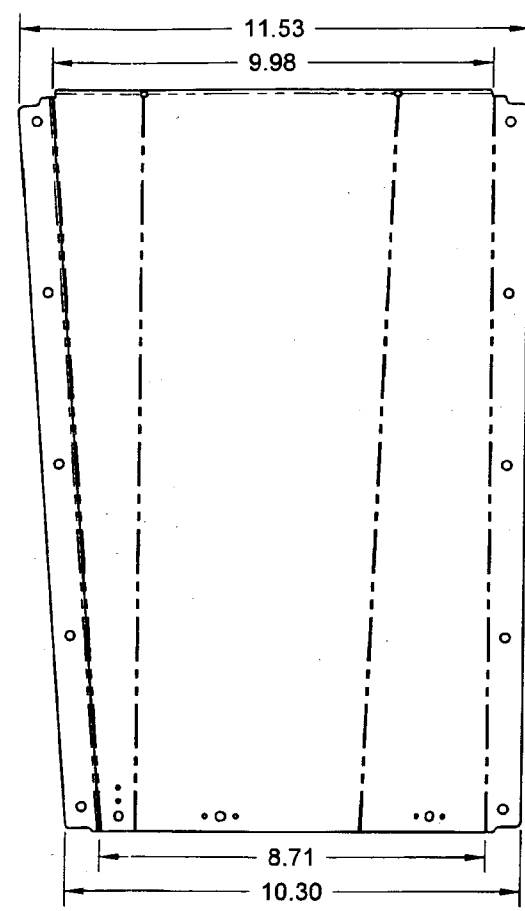
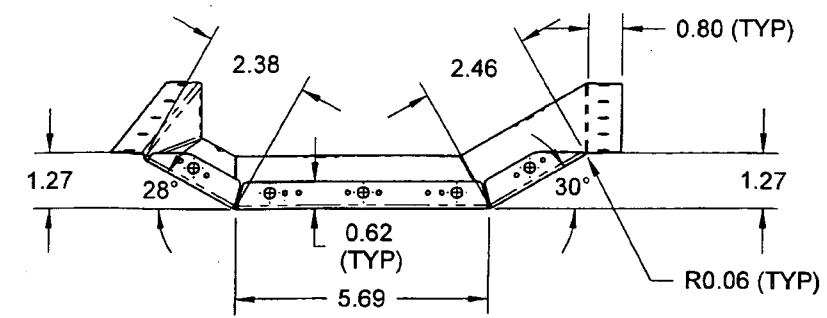


D3650-1 AFT PANEL

PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

- NOTES:
1) FINISH: NONE
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: NONE
6) WEIGHT: 1.3 lbs



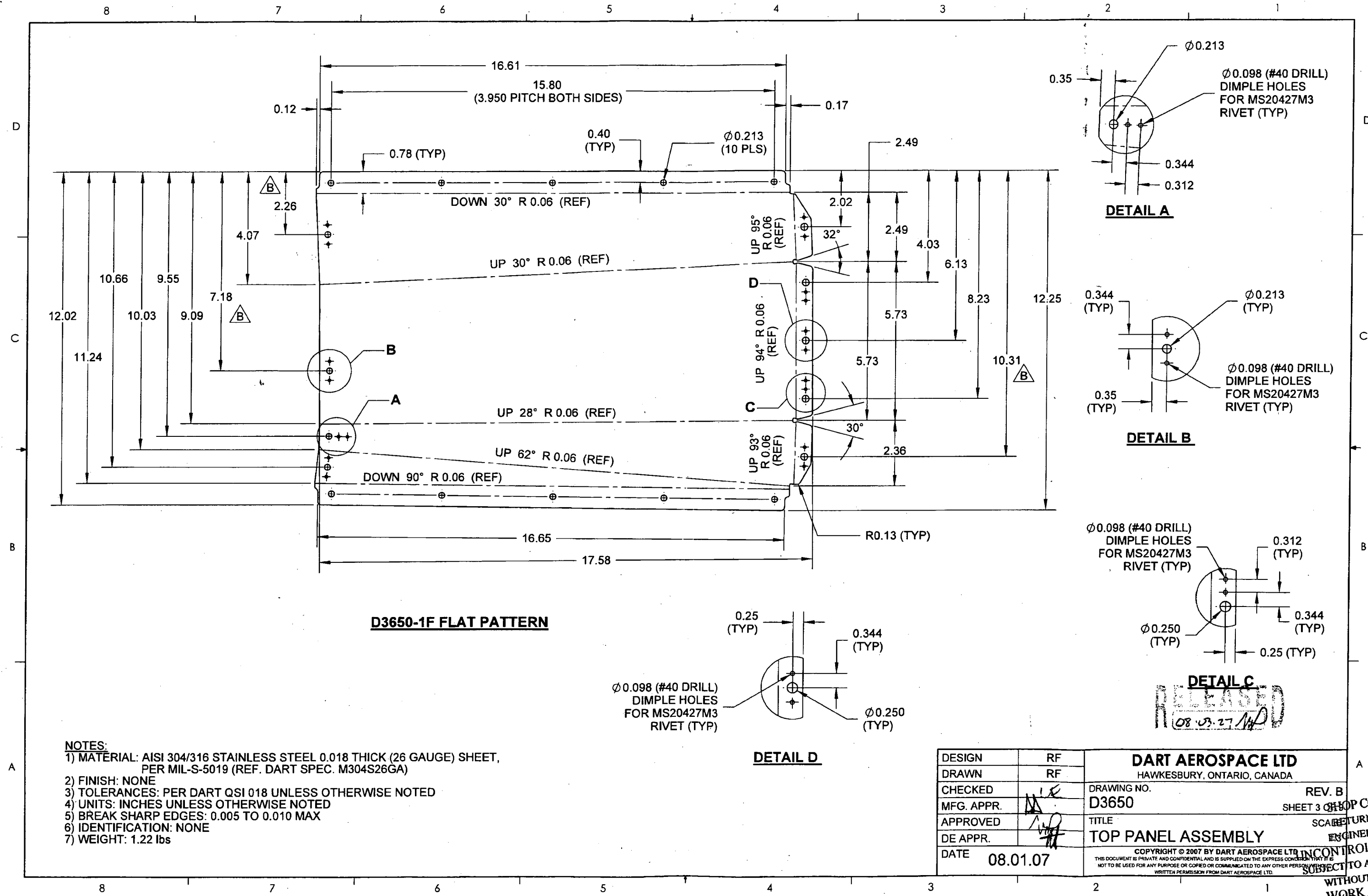
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

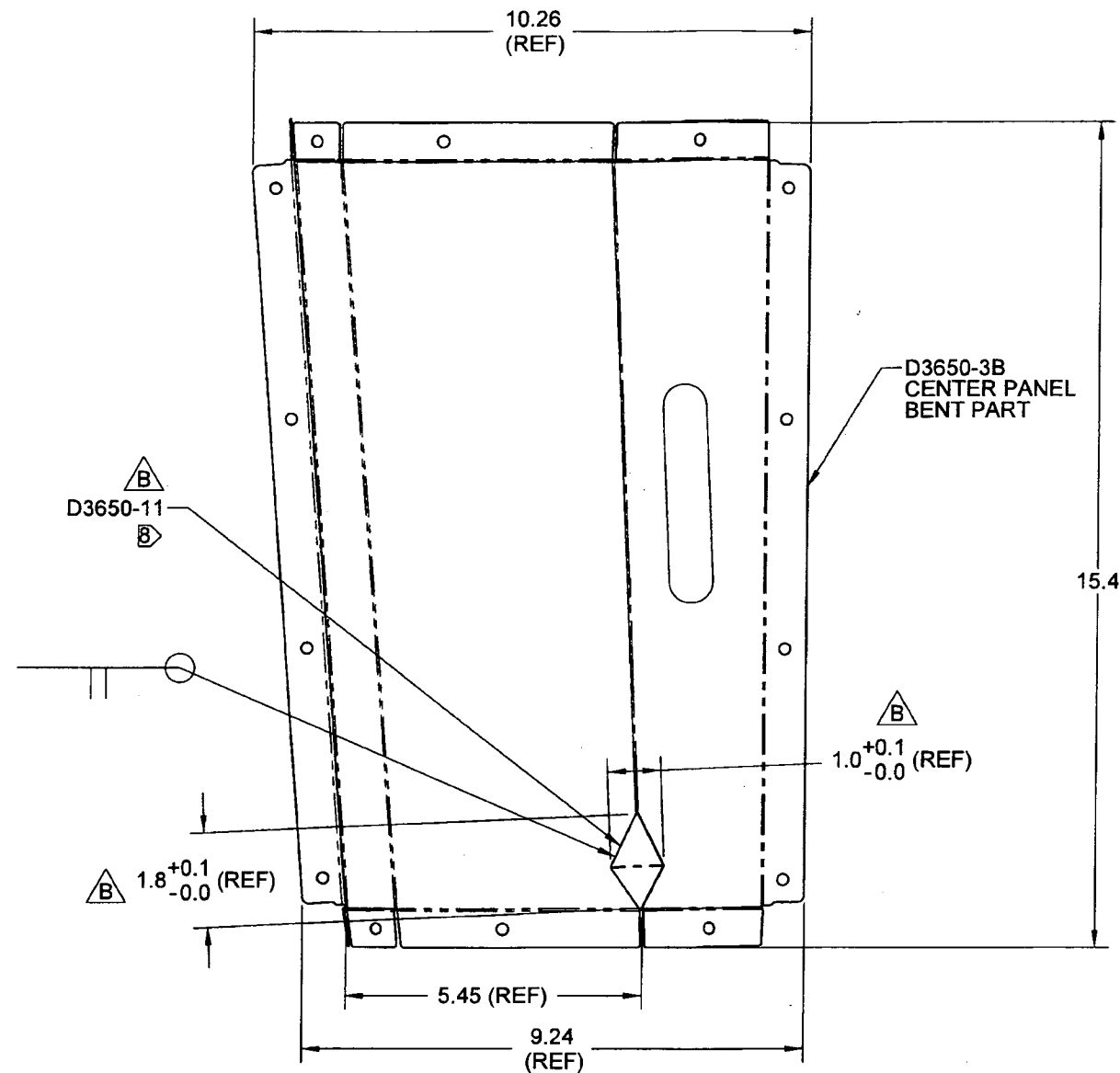
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08-03-27

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:1
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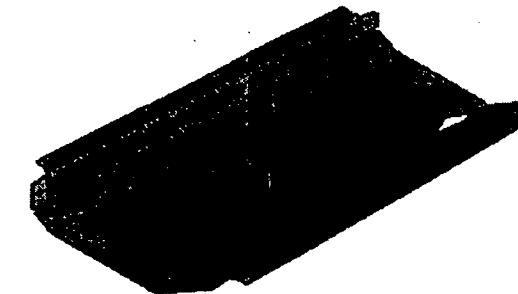
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8 7 6 5 4 3 2 1





D3650-3 CENTER PANEL



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

NOTES:

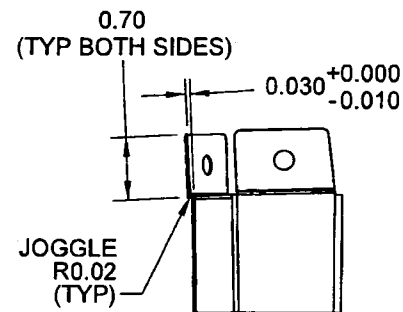
- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



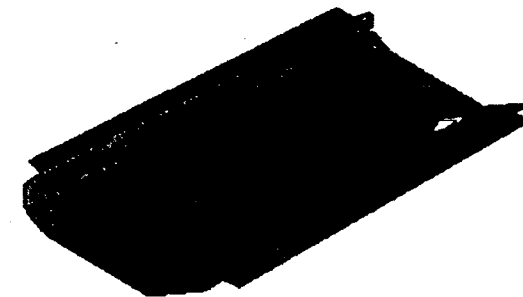
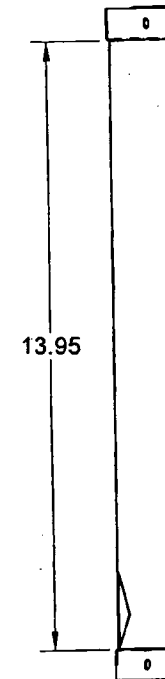
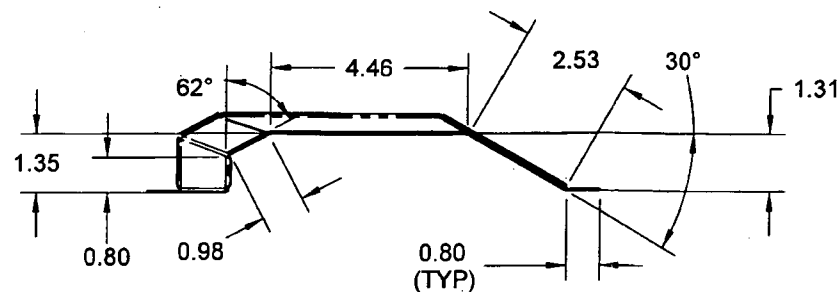
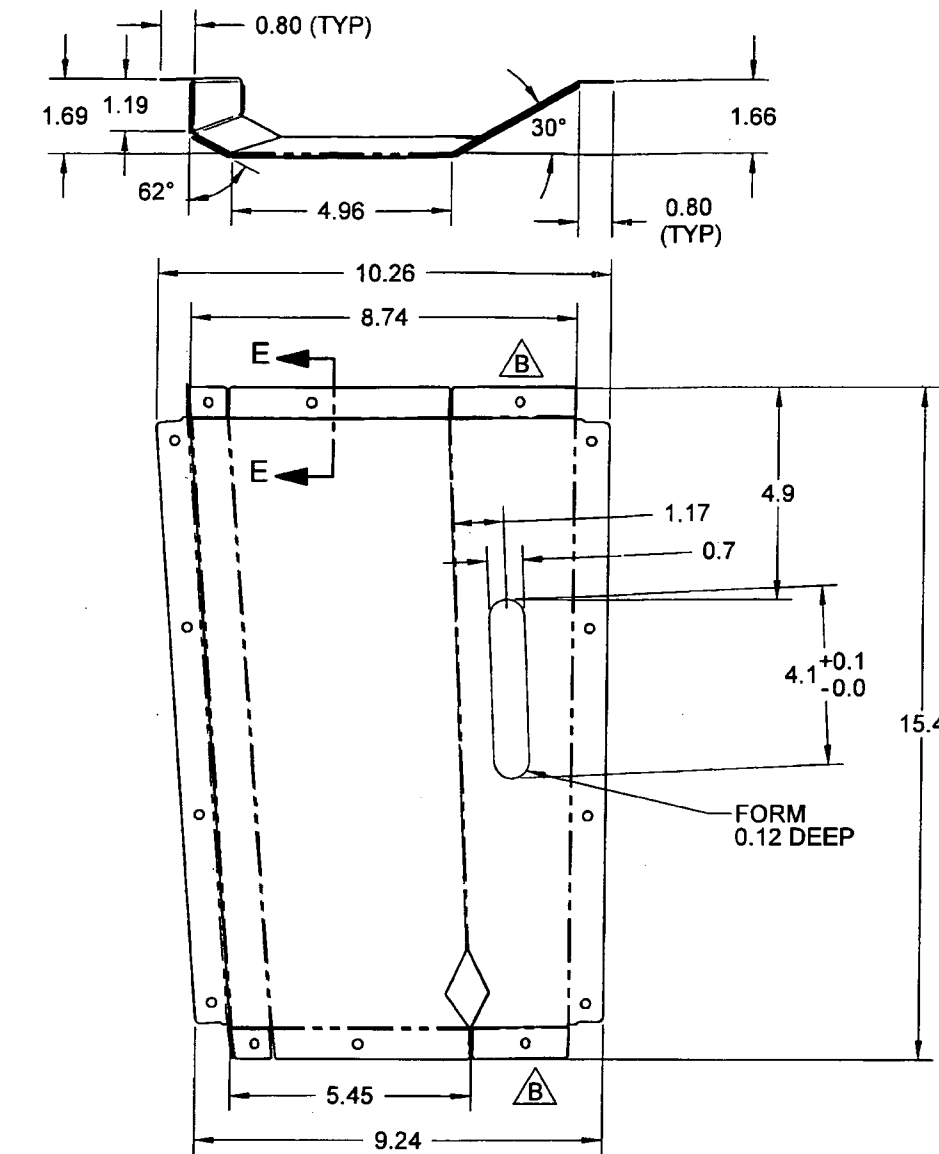
RELEASED
08-03-27

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	WE	DRAWING NO. D3650
MFG. APPR.	DA	REV. B
APPROVED	WGP	SHEET 4 OF 9
DE APPR.	WGP	SCALE 1:3
DATE 08.01.07		TITLE TOP PANEL ASSEMBLY
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SECTION E-E



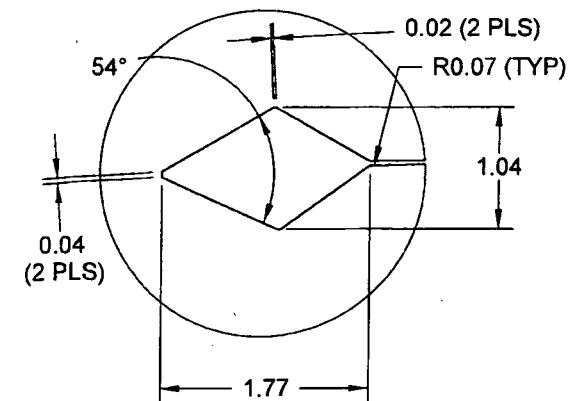
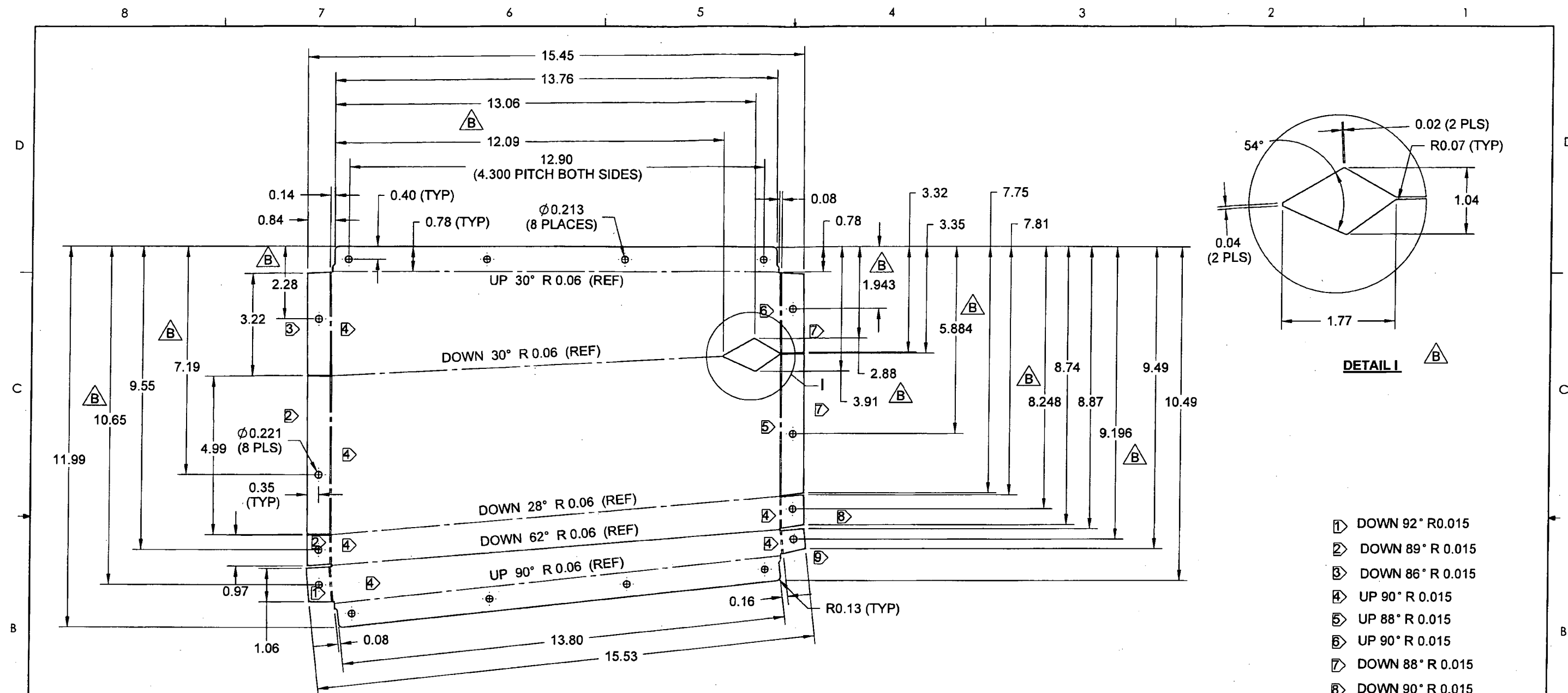
- NOTES:**
 1) FINISH: NONE
 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 5) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
 (MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	
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DETAIL I

D3650-3F CENTER PANEL FLAT PATTERN

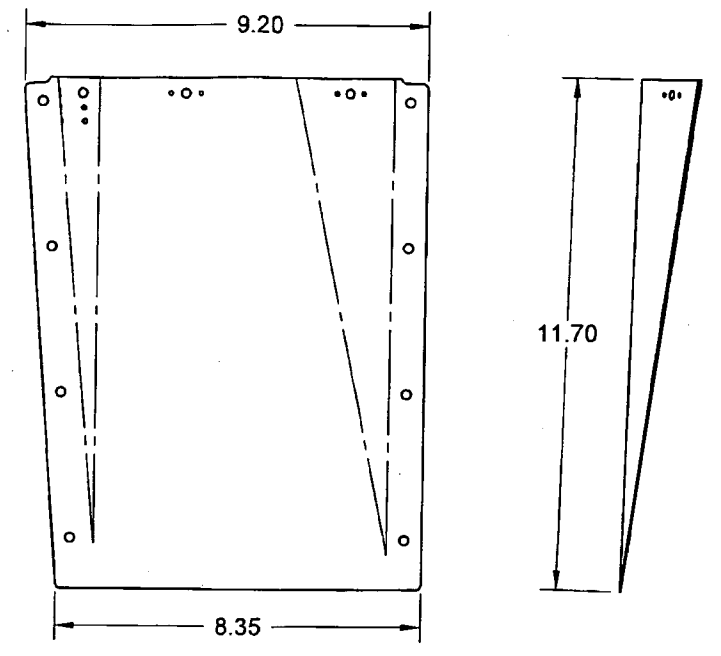
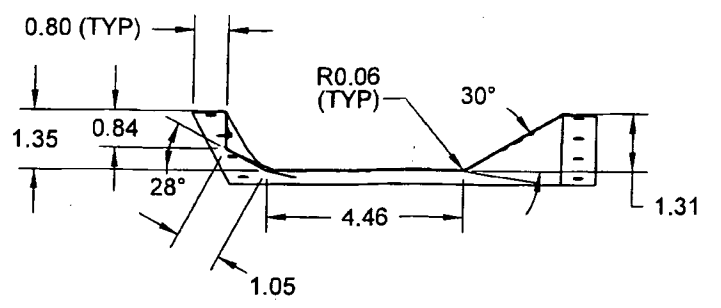
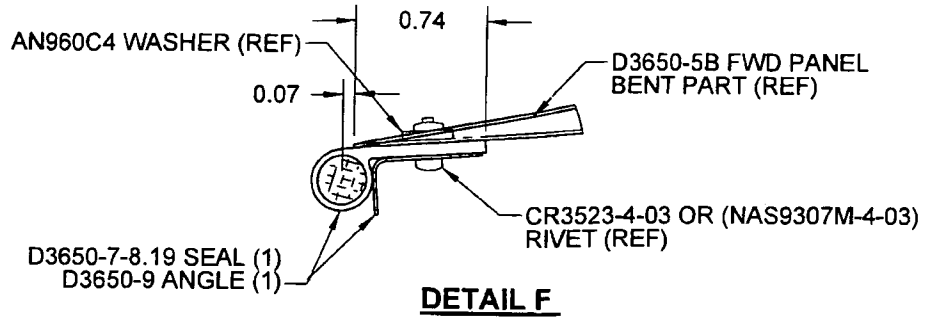
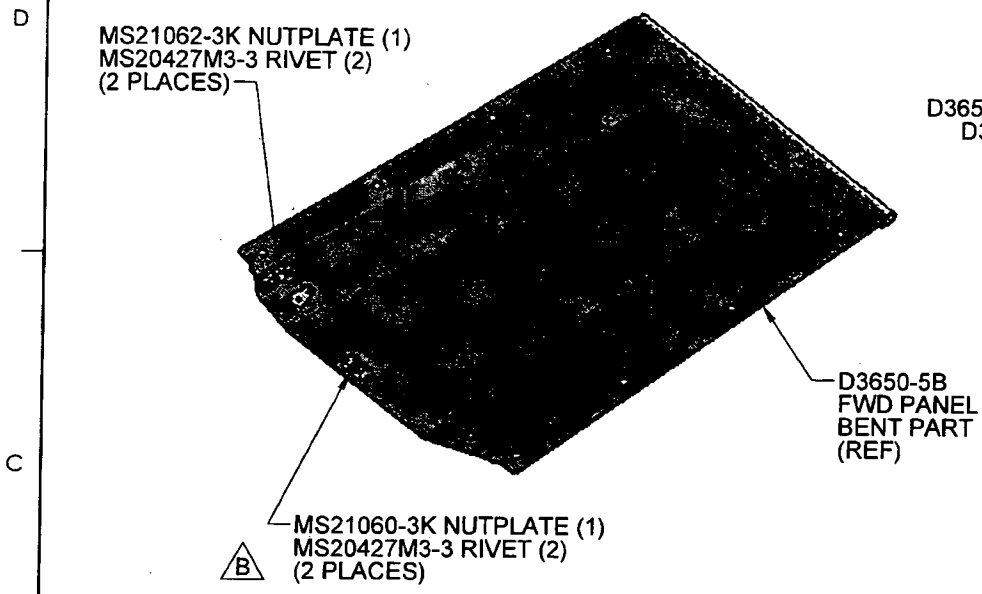
D3650-3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3650	SHEET 6 OF 9
APPROVED	MP	TITLE	TOP PANEL ASSEMBLY
DE APPR.	MP	COPYRIGHT © 2007 BY DART AEROSPACE LTD. UNCONTROLLED COPY	
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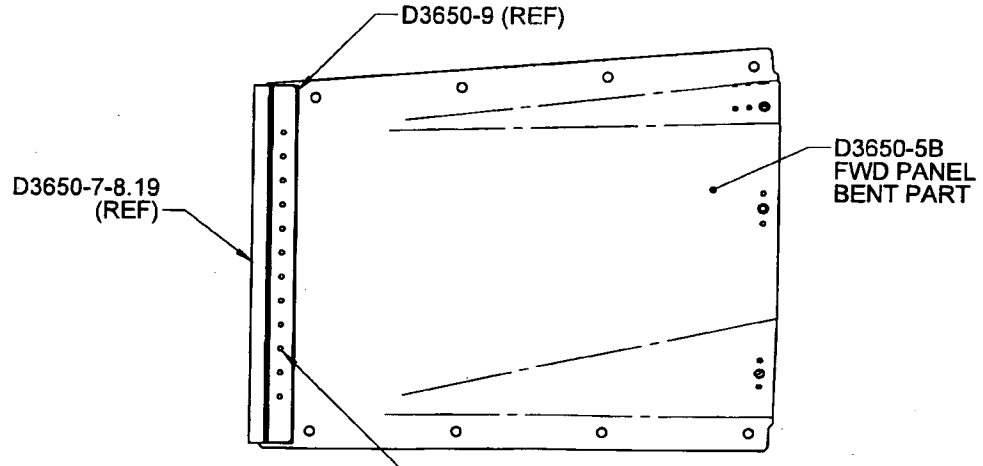
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WORK ORDER
NO. 42094

8 7 6 5 4 3 2 1



PART LIST

QTY	PART NUMBER	DESCRIPTION
5	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE



CENTRE D3650-7/-9 ON D3650-5B & TRANSFER $\phi 0.129$ (#30 DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN
INSTALL CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)

D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

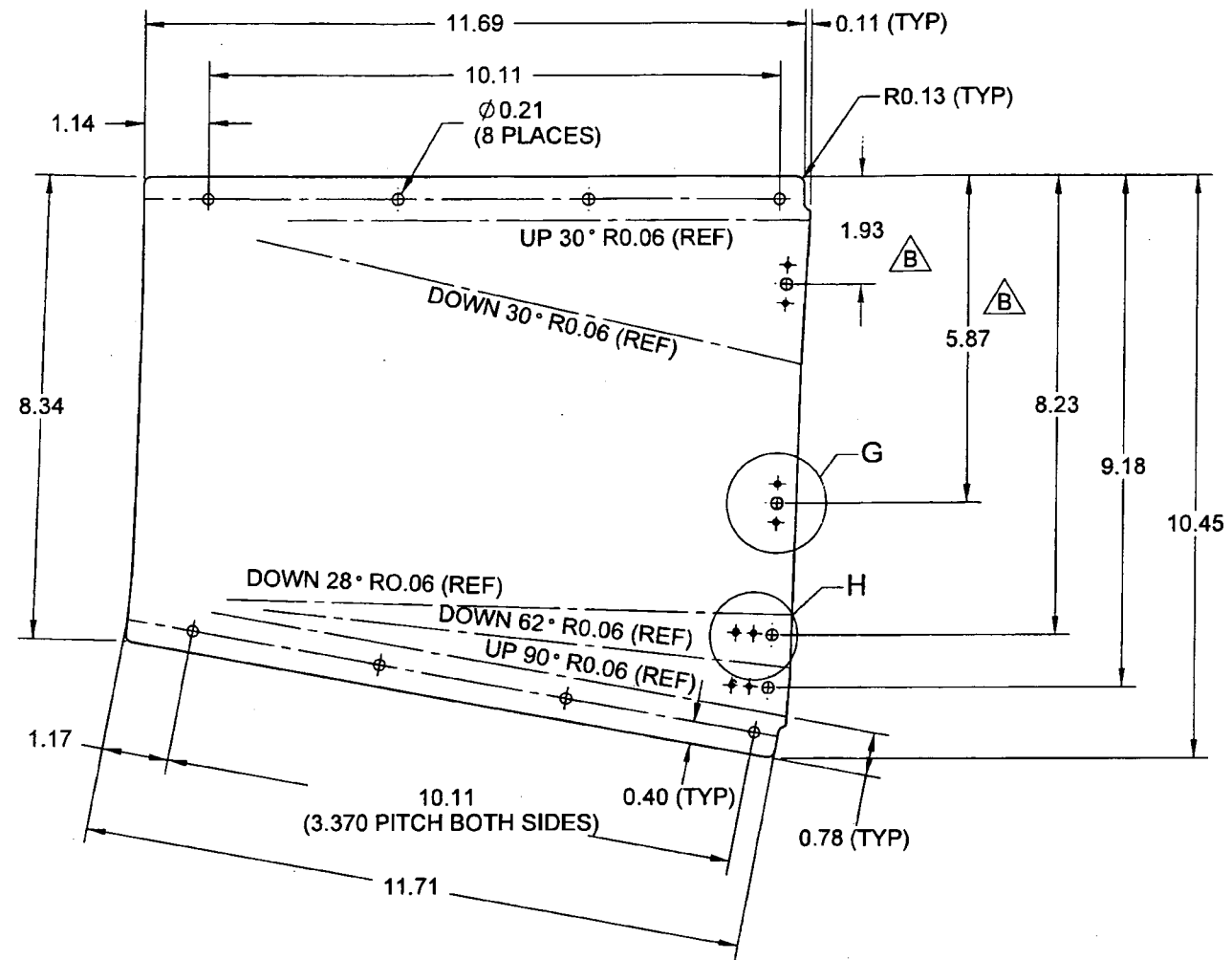
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.8 lbs

D3650-5 FWD PANEL

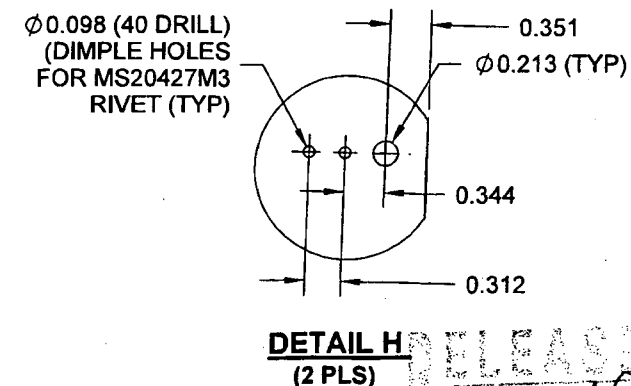
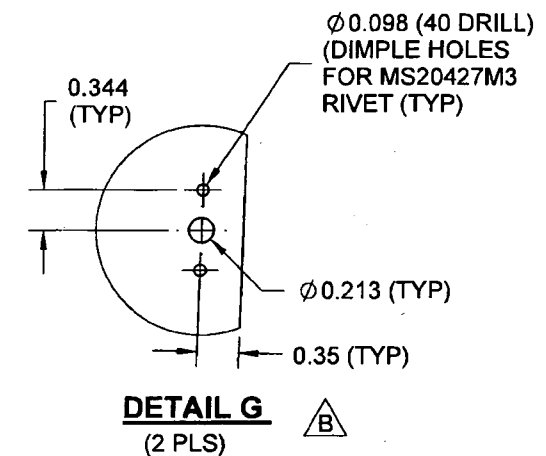
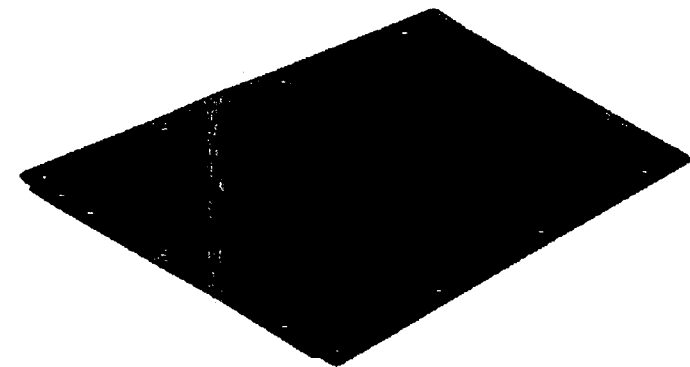
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	RF	DRAWING NO. D3650
MFG. APPR.		REV. B
APPROVED		SHEET 7 OF 9
DE APPR.		TITLE TOP PANEL ASSEMBLY
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NO. 40094

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D3650-5F FLAT PATTERN

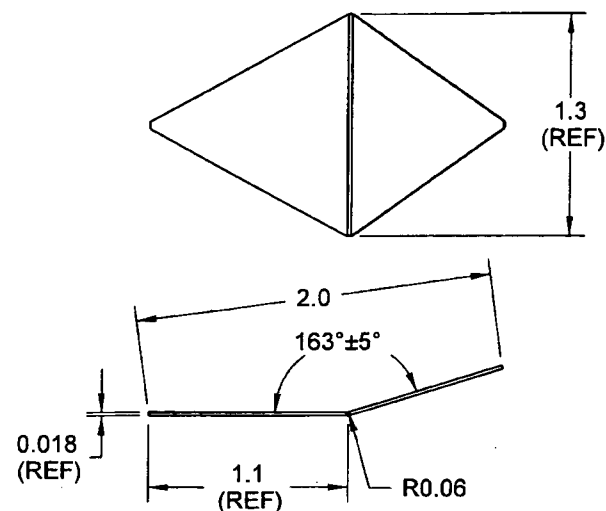


NOTES:

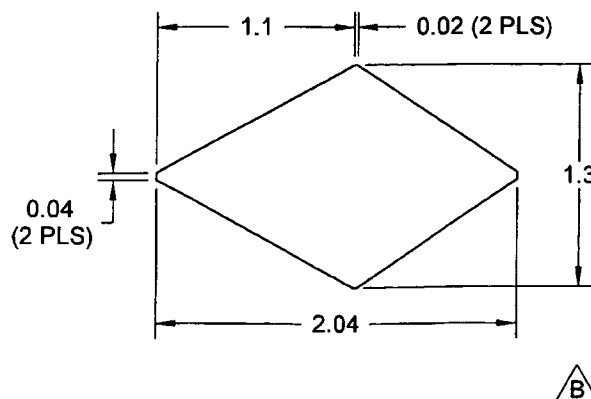
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 8 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	1:3
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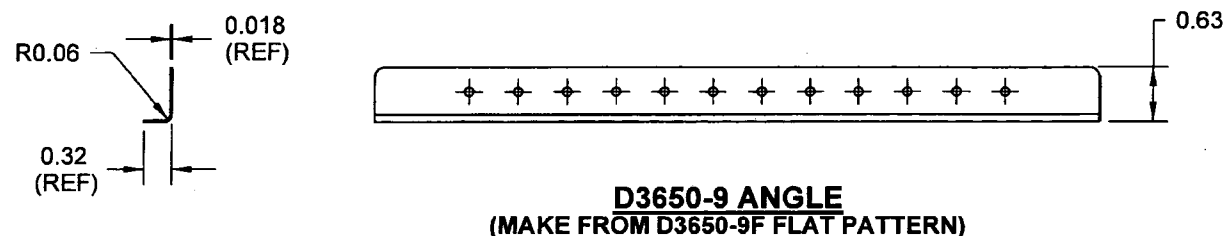
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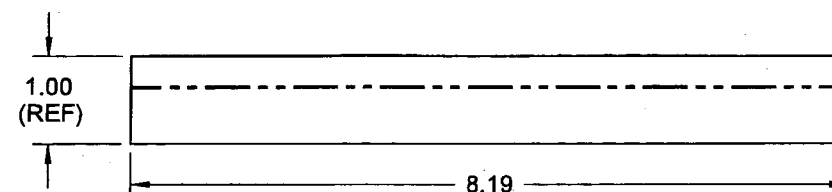
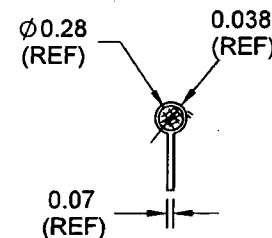
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



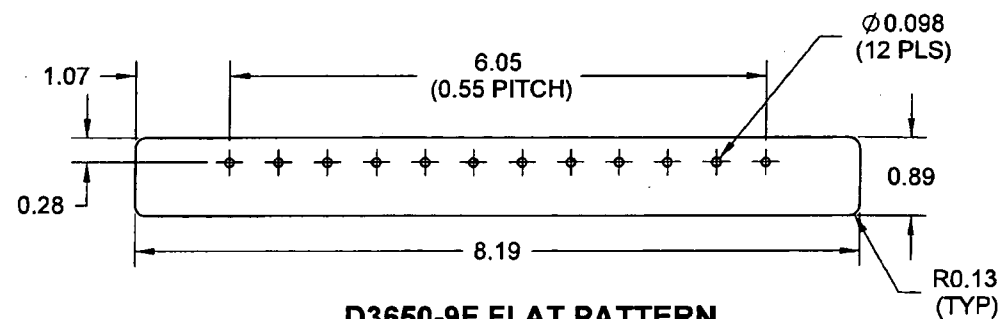
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 9 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	1:2
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